

Date: Tuesday, 4/17/2007 3:46:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW
Job Number : 31884	
Estimate Number : 10495	
P.O. Number : <i>NIA</i>	Part Number : D2360
This Issue : 4/17/2007 S.O. No. : <i>NIA</i>	Drawing Number : D2360/D2341 UNDERREV <i>OK</i>
Prsht Rev. : NC	Project Number : N/A <i>CB</i>
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : C1 / E <i>07.04.18</i>
Previous Run : 29136	Material : <i>NIA</i>
Written By : <i>JL 07.04.18</i>	Due Date : 5/2/2007 Qty: 4 Um: Each
Checked & Approved By : <i>JL 07.04.18</i>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.1067 f(s)/Unit Total : 4.4268 f(s)
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)
 Batch: *329367*

JL 07/05/18 4

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 12.65" Long

JL 07/05/18 4

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio D2341 and Dwg D2341

JL 07/05/18 4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/05/18 4

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JL 07/05/18 4

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Deburr and Tumble

JL 07/05/18 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:46:38 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 31884

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



2005.22 (40)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 07/05/24

POSITIVE
RECALL

9.0

POWDER COATING

POWDER COATING



M103141

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

07-05-25 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-05-31 (4)

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Knob

B16177B

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Lock Channel

B29144

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Inventory

B9288 B31955

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Inventory

B29144 7/5/28 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:46:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 31884

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Quick Release

B29147

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spring

B26438

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pip Pin Assembly

B28379

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M4523

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M104118

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

M103044

21.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet, Universal Head

M7890

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

④ M103641 M103691

7/6/28 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: FD Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:46:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 31884

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M13719

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

M104156

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut

M1463 6/10/28 SD

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

MF 07-05-31

(4)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2706-04 (4)



28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

2707-46/05 (4)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2707-106/05

(4)

Job Completion



POSITIVE RECALL

EFFECTIVE 07-05-22 AUTH

RELEASED DATE 7/26/05

W 27-2605

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31884
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.503	✓			
1.000	+/-0.010	1.000	✓			
Ø0.242	+0.005/-0.001	.242	✓			
Ø0.191	+0.005/-0.001	.191	✓			
R0.250	+/-0.010	0.250	✓			
1.700	+/-0.010	1.701	✓			
0.750	+/-0.010	.749	✓			
2.750	+/-0.010	2.757	✓			
11.000	+/-0.005	10.999	✓			
5.500	+/-0.010	5.500	✓			
1.584	+/-0.010	1.580	✓			
Ø0.191	+0.005/-0.001	.191	✓			
2.610	+/-0.010	2.606	✓			
0.844	+/-0.010	.843	✓			
1.250	+/-0.010	1.246	✓			
0.750	+/-0.010	.753	✓			
12.500	+/-0.010	12.503	✓			
3.313	+/-0.010	3.318	✓			
4.250	+/-0.010	4.249	✓			
0.400	+/-0.010	.400	✓			

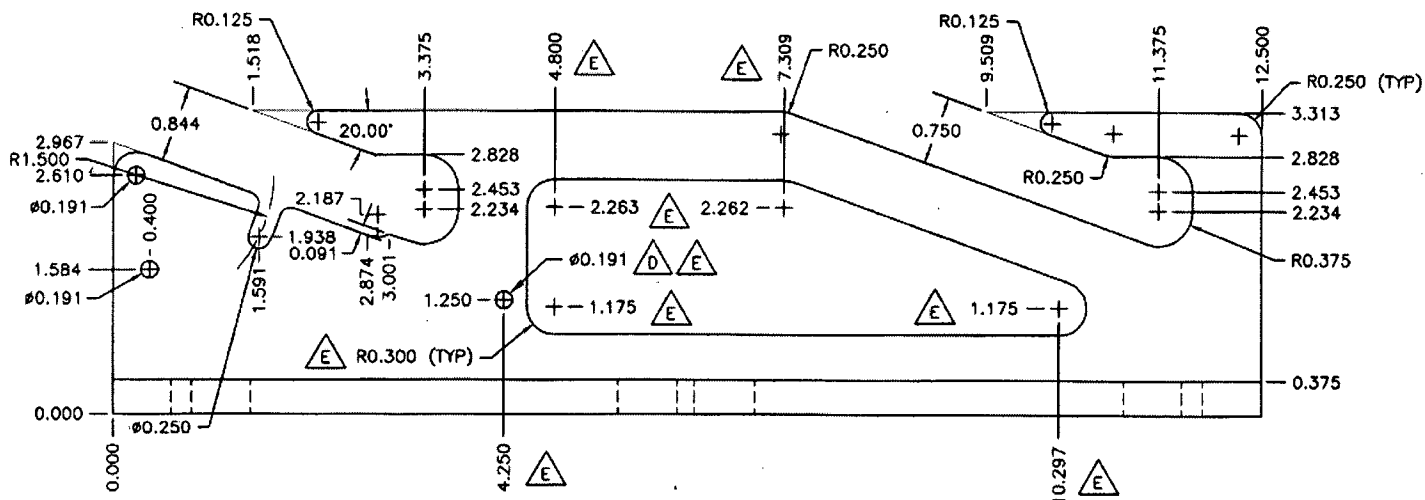
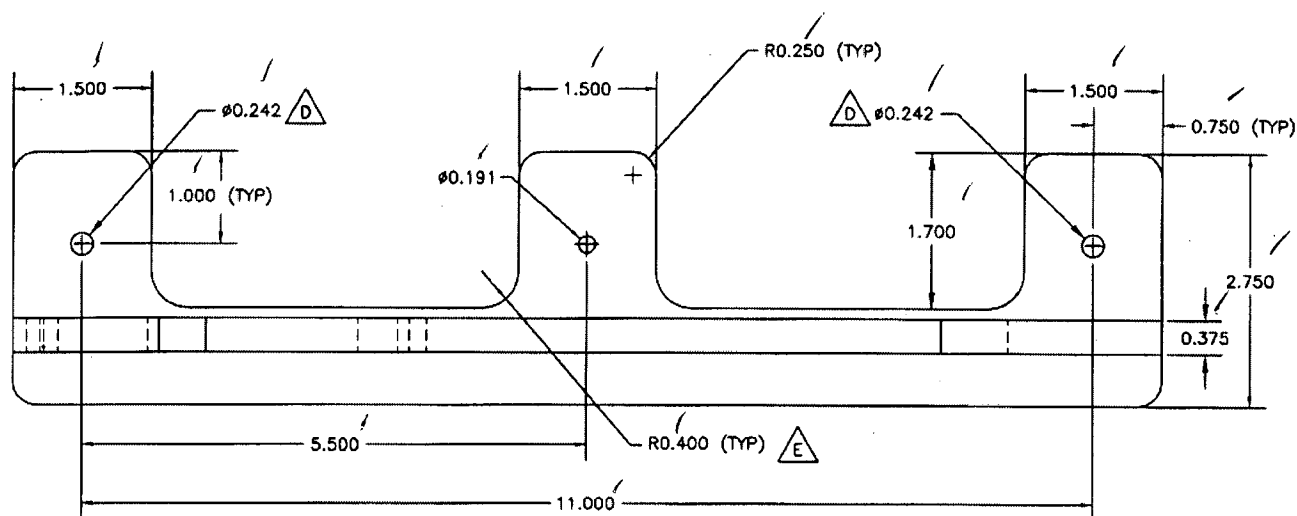
Measured by:	3L	Audited by:	MB	Prototype Approval:	N/A
Date:	07/05/17	Date:	07/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MM	APPROVED BW	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR A130



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION

FINISH: ANODIZE ① ALUMINE PER QSI OCT 4.1

② POWDER COAT PER QSI OCT 4.3

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WORK ORDER
NO. 31884



DESIGN BW	DRAWN BY BW	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED DIOX	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
C1	02.09.24	D2002-015 WAS D2376	

RELEASED
97.08.27 BW

UNDER REVIEW

06.06.23 CB

draw update
continue nfg

OK

CB

07.01.18

KE 97.09.02

D2360	Part No.	Description
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2376	KNOB (DELRIN) D2002-015
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
3	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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DART

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>MB</i>	DRAWING NO. D2360	REV. C SHEET 2 OF 2
DATE 97.08.27	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)		

